

Date: Wednesday, 1/11/2006 4:21:11 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BRACKET ASSEMBLY
Job Number	25441D			
Estimate Number	10281			
P.O. Number	N/A		Part Number	D3183043
This Issue	1/11/2006	S.O. No. : N/A	Drawing Number	D3183 REV C1
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type : MACHINED PARTS	Drawing Revision	C1
Previous Run	24266D		Material	N/A
Written By	SEE COMMENT BELOW			Due Date : 2/18/2006
Checked & Approved By	SEE COMMENT BELOW			Qty: 4 Um: Each
Comment	Est Rev:Pick:A 04.02.18 New issue KJ/DS			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M174B2000X01500	17-4 SS Bar
	Comment: Qty.: 0.4812 f(s)/Unit Total : 1.9249 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.500x02.000) Identify for D3183-043 Batch: M14773	
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW 1.500" Cut blanks: (1.000" x 2.000") 5.500" long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3183-3 as per Folio FA322 and Dwg D3183 Identify as D3183-3 2-Deburr 3-Scribe batch number	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:21:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25441D

Part Number: D3183043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 06.01.20 4

6.0 D312121 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3121-21 Bolt B24224 X8

BC 06.01.20 4

7.0 D3183045 Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3183-045 Bearing Ass B23974 X8

BC 06.01.20 4

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3183-043 as per Dwg D3183.

BC 06.01.20 4

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BC 06.01.20 4

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 4C3

C 06/01/20 4

4

11.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

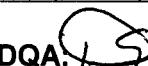
Inspection Level 21 5 ac 06/01/25 4

5 ac 06/01/24

Job Completion



W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

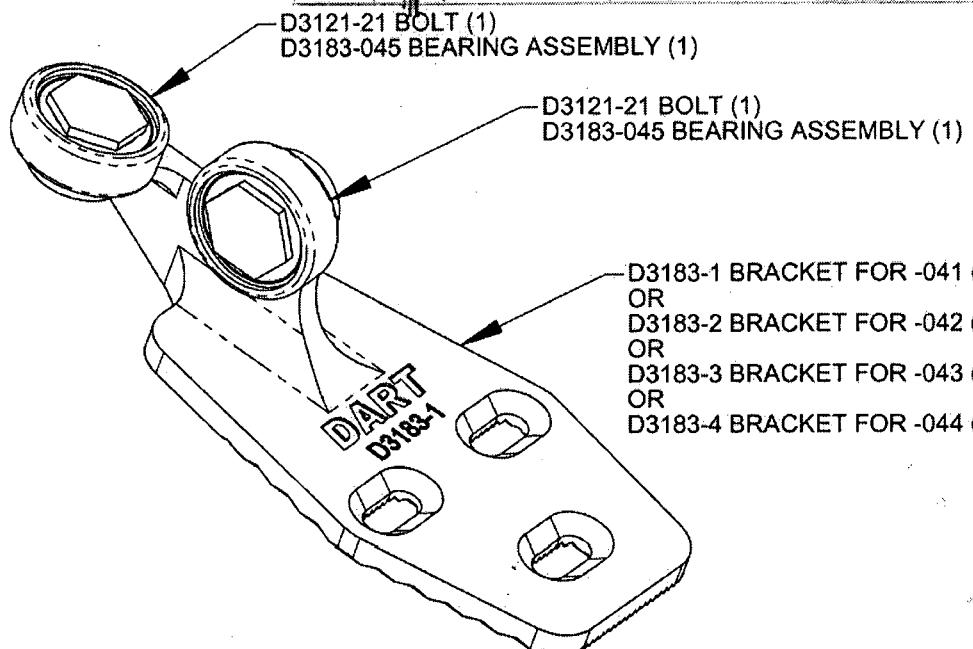
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

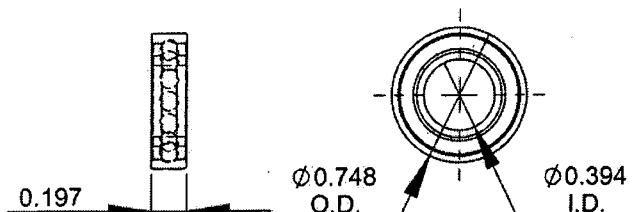
NOTE: Date & initial all entries

DARTCOPY IS
HERE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 1 OF 4
DATE	04.02.17	TITLE	SCALE 1:1

RELEASED
04.03.01

D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

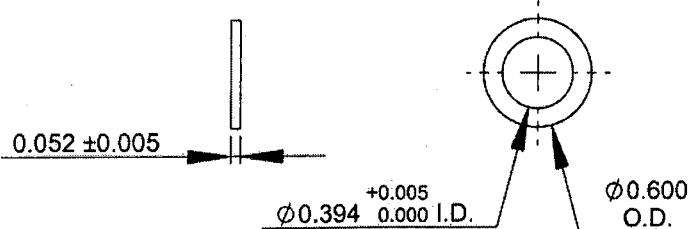


SHOP COPY
SPECIFICATION CONTROL DRAWING

1) SINGLE ROW, DEEP GROOVE,
CONRAD TYPE, SHIELDED, *NOT TROLLED COPY*
2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
3) ALL DIMENSIONS ARE IN INCHES *NO AMENDMENT*
NOTICE

WORK ORDER

NO 2544/1D

D3183-7 WASHER

1) MATERIAL: AISI 303 ROUND BAR (M303R)
ANNEALED
2) BREAK ALL SHARP EDGES 0.005 TO 0.010
3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

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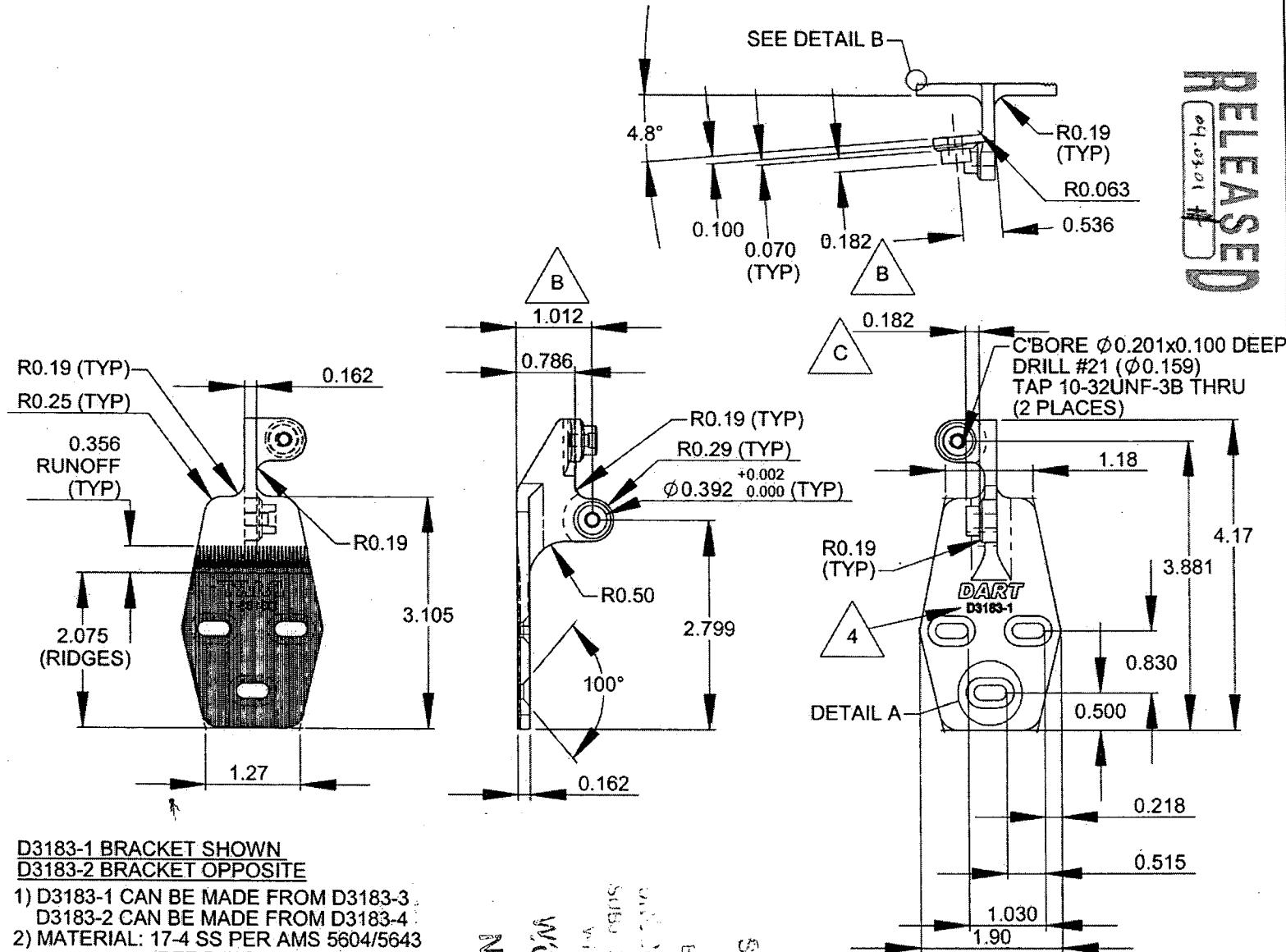
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D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 15
MIN YIELD STRENGTH = 100 ks
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNL
OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



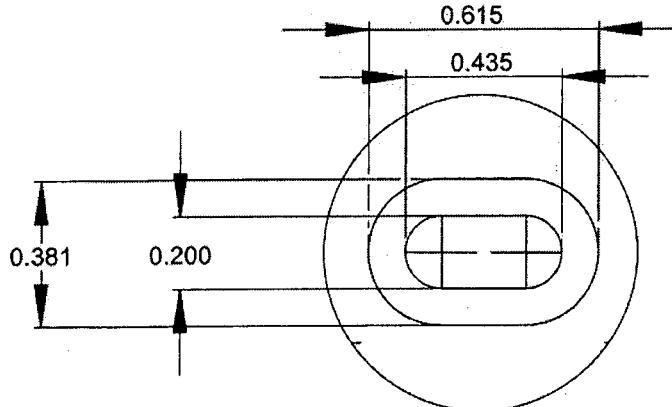
10. IT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25441 D
O
ESS

RETURN TO
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OR UNROLLED COPY
SUBJ. TO AMENDMENT
WITH-HOLD NOTICE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3183
DATE	TITLE	REV. C SHEET 2 OF 4 SCALE 1:2
04.02.17 BRACKET ASSEMBLY		

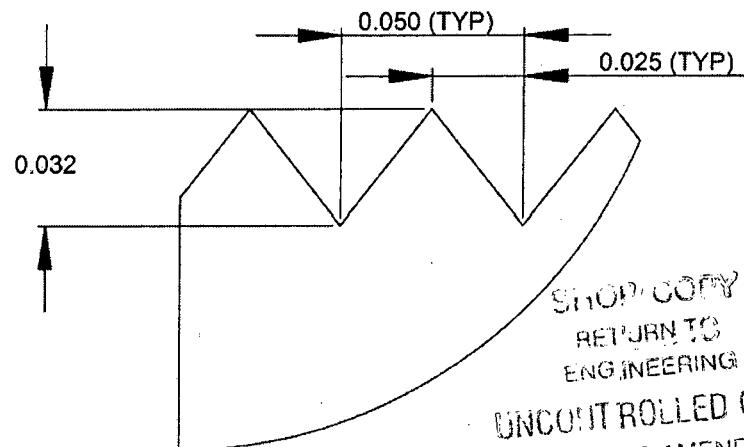


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CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 4 OF 4
DATE	04.02.17	TITLE	SCALE
		BRACKET ASSEMBLY	1:1



DETAIL A (2 : 1)

RELEASED
04.03.01

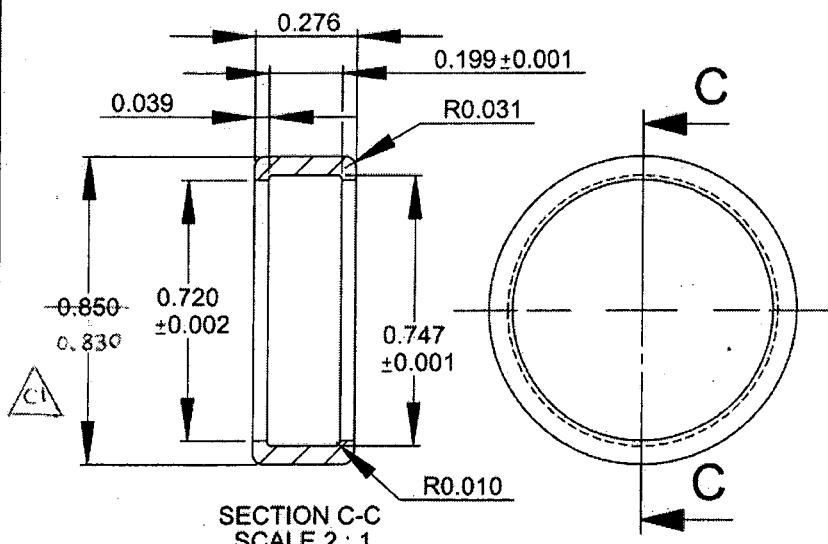


DETAIL B (20 : 1)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. Z5441 D



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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DART AEROSPACE LTD		Work Order: 26441 D
Description: Bracket		Part Number: 3183-3
Inspection Dwg: 3183	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.08	±.03	2.08	✓			
1.155	±.010	1.155	✓			
.71	±.03	.71	✓			
4.26	"	4.26	✓			
.162	±.010	.165	✓			
1.012	"	1.009	✓			
.786	"	.776	✓			
3.954	"	3.960	✓			
.162	"	.156	✓			
.392	±.003	.392	✓			To f.t. Bearing
.100	±.010	.092	✓			
.070	"	.066	✓			
.182	"	.182	✓			
.201 X .100	+.005 / -.001	.206	✓			C-bore
.159	±.005	.162	✓			
.332	±.03	.334	✓			
.365	±.010	.364	✓			
.218	"	.211				
1.90	±.03	1.886	✓			
.032	.032 ±.010	.032	✓			Serration depth

Measured by: BG	Audited by: SA	Prototype Approval:
Date: 06.01.19	Date: 06.01.20	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	